



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-022
Job Sheet 187141



7477

Part No: D350-636-022**Job Qty:** 1 ea**Part Name:** AS350/355 - Skidtube - Standard w/ Standard Wearplates - RH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/28/18**Job Tracking No:****Due Date:** 1/9/19**Created By:** Jesse White**Type:** Stock**Description:** SIOP**Note:** D2750-052 REV.H, IIN-D350-636 REV.K IPP REV.A 18.11.27 NEW ISSUE DD VERF:JFS**Ship Via:****Bill of Materials****Container No:** S133783**Part:** D350-636-022**Job No:** 187141**Serial No/Batch:** S133783**Revision:** 4/K**Inspector:****Exp Date:****Instructions:** TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/9/19	0.00	0.00	Start Up Skidtubes-1		BE
110	Skidtubes	1 pcs		1/9/19	0.00	4.36	Skidtubes-4		BE DAS 38 9-89 38
120	QC	1 pcs		1/9/19	0.00	0.00	QC10		
130	QC	1 pcs		1/9/19	0.00	0.00	QC5		
140	HandFinish	1 pcs		1/9/19	0.00	0.91	HandFinish1		D.R. 18/12/19
150	QC	1 pcs		1/9/19	0.00	0.00	QC7-2		BE
160	Skidtubes	1 pcs		1/9/19	0.00	4.36	Skidtubes-1		TE, BE, Juf
170	QC	1 pcs		1/9/19	0.00	0.00	QC10		PD 19-01-02
180	QC	1 pcs		1/9/19	0.00	0.00	QC5		PD 19-01-02
190	HandFinish	1 pcs		1/9/19	0.00	0.91	HandFinish2		D.R. 19/01/03
200	SprayPaint	1 pcs		1/9/19	0.00	0.69	Spray Paint		AB 19-1-4
205	Outsource	1 pcs		1/9/19			ATE003-VC	5	NR
210	QC	1 pcs		1/9/19	0.00	0.00	QC14		DAS 9-89
230	HandFinish	1 pcs		1/9/19	0.00	0.91	HandFinish4		BE 19-01-03
240	QC	1 pcs		1/9/19	0.00	0.00	QC5		JAN 14 2019 68
250	Packaging	1 pcs		1/9/19	0.00	0.00	Packaging1-3		DAS 6 JAN 2019 9-89
260	QC	1 pcs		1/9/19	0.00	0.00	QC4		9-89 48S JAN 15 2019
270	Packaging	1 pcs		1/9/19	0.00	0.00	Packaging3-1		21 9-89 JAN 15 2019
275	DC	1 pcs		1/9/19	0.00	0.00	DC		21 9-89 JAN 15 2019
280	QC21-FG	1 Ea		1/9/19	0.00	0.00	QC21		JAN 15 2019

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 (D2750-6 details). Drill using drill Jig DT8150 & DT8863A Descriptions: for second side only DT8863B for first side 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail BM to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

160 - 1- Open up holes of Detail BN using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4- Chamfer holes of Detail BN, ground handling and float holes per dwg D2750 (welding instructions on sheet 16) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: M138943 exp. date: 19/3/06 **ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 138673 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 138976 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 140325

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 5128386 EXP DATE: 19/03 5- Coat all exposed fasteners with "LPS Procyon" batch: M133690

270 - Package as per PPP D350-636-012

275 - record fwd angle: 89.8° Photocopy blue file and type labels per PPP D350-636-012 CHG 008

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :	MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 Ea (1 ea)	90-Start up Operation	5109438
D2744	Cap	1 Ea (1 ea)	110-Skidtubes	5060499
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5126363
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5133725
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	29x5095214 / 5x507599 9
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5142453
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	1x5006333 / 3x51366 58
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5142143
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5135705
D3488-4	Blade Fitting, RH	1 Ea (1 ea)	230-HandFinish	5128529
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5108684
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5058407
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5097206
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5127534
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5127536
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5092449.5093 614
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5090633
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5130139
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5083559
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5058138
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5117121
D3793-5	Wearshoe	1 Ea (1 ea)	230-HandFinish	5132949
MS21043-3	Nut	1 Ea (1 ea)	230-HandFinish	5099569
NAS1149C0363R	Washer	2 Ea (2 ea)	230-HandFinish	5135100
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5084120
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5129315
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5104046
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5133189

M. U. 007467

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	22	0
110-Skidtubes	D2744	1	20	0
160-Skidtubes	D2739	1	17	0
	D2743	8	39	0
230-HandFinish	ALS4-1032-225	38	1,319	0
	AN3C34A	1	20	0
	AN3C5A	34	1,502	0
	AN3C6A	4	165	0
	AN6C44A	4	103	0
	AN8C35A	1	34	0
	D2745	8	103	0
	D3488-4	1	10	0
	D3537-1	3	204	0
	D3631-1	8	407	0
	D3791-1	1	16	0
	D3793-1	1	15	0
	D3793-3	1	13	0
	D3793-5	1	0	0
	MS21043-3	1	886	0
	MS21043-6	4	109	0
	MS21083C8	1	121	0
	NAS1149C0332R	38	3,530	0
	NAS1149C0363R	2	99	0
	NAS1149C0832R	1	370	0
	NAS1515H3L	4	405	0
250-Packaging	AN8C21A	2	73	0
	D2741	1	85	0
	MS21083C8	2	121	0
	NAS1149D0863J	2	72	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Part Specifications

Specifications could not be found.

Plex 11/28/18 9:53 AM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-6/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B6-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN860C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN860C816L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.01/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AST SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN860C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/8157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 1 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED

2018 OCT 19
2018-05-05

APPROVED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

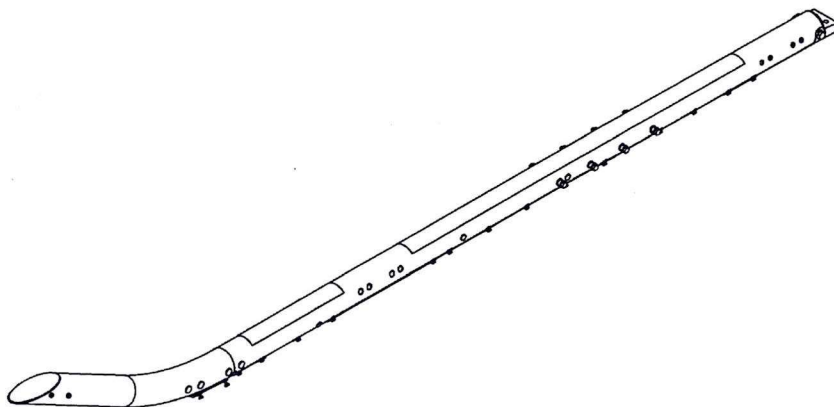
8 7 6 5 4 3 2 1

D

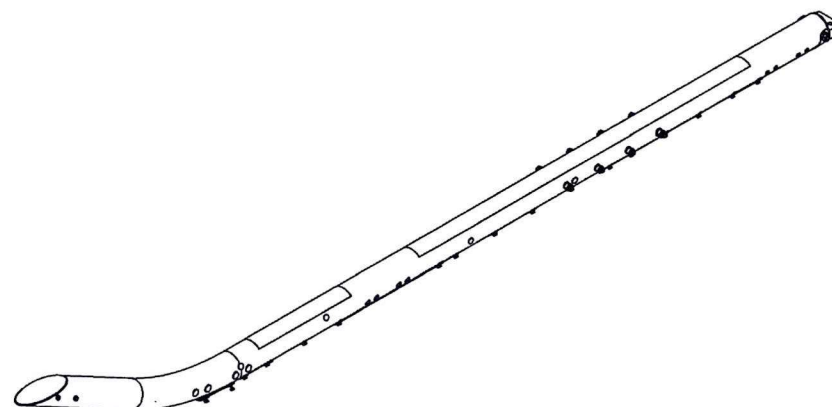
C

B

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED

2018 OCT 19
Oct 19 1980

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 2 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS-#	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

D

C

B

A

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

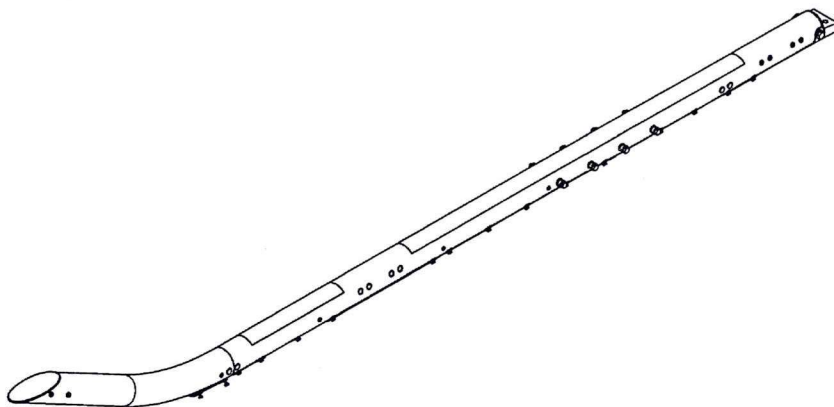
8 7 6 5 4 3 2 1

D

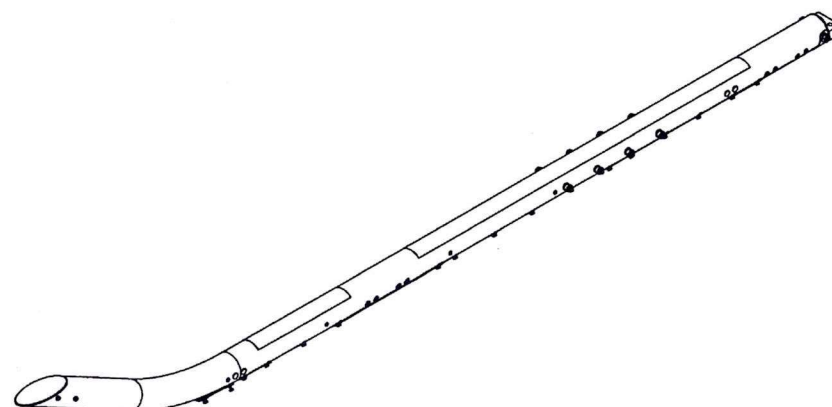
C

B

A



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

Entered: _____ Date: _____

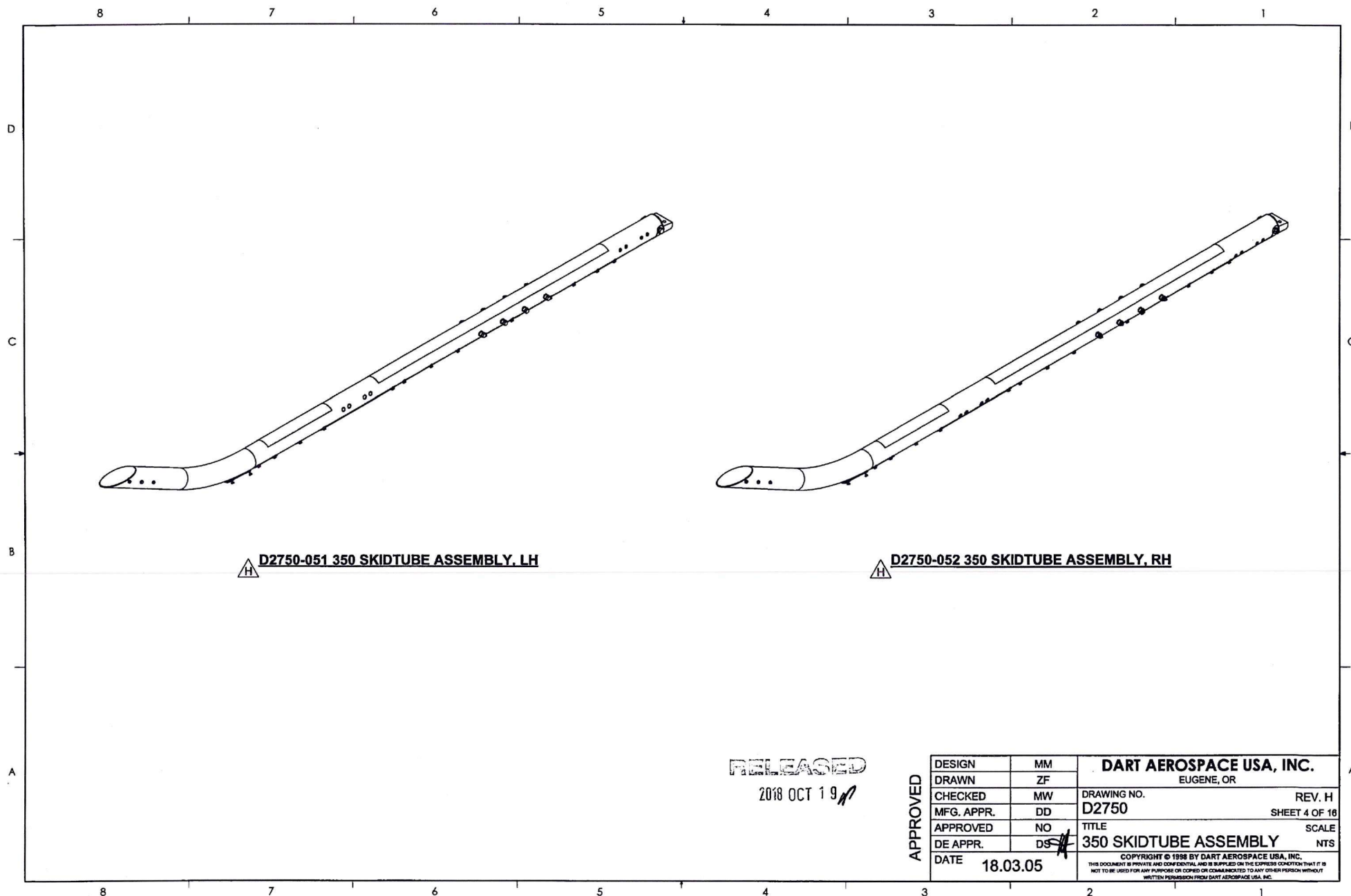


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Entered: _____ Date: _____

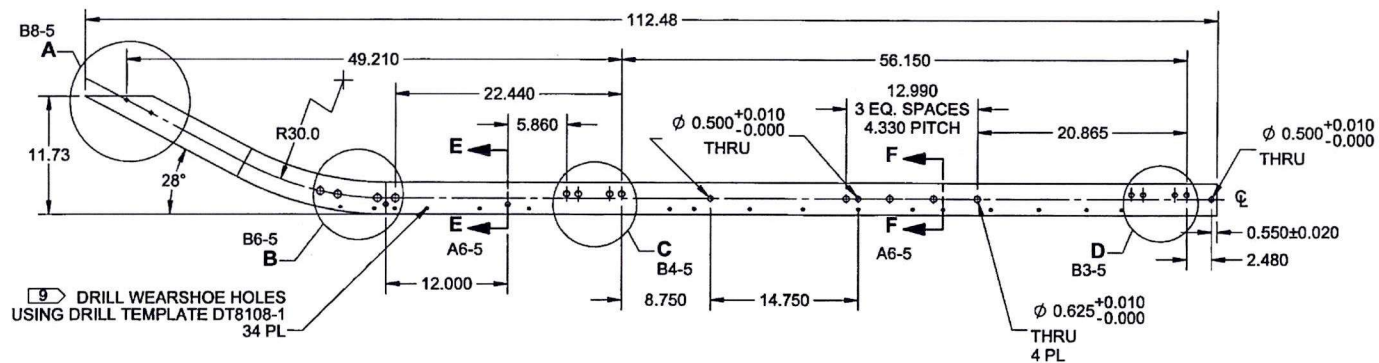


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

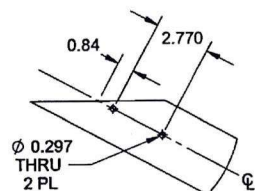
NCR No. _____

Route update only ☐

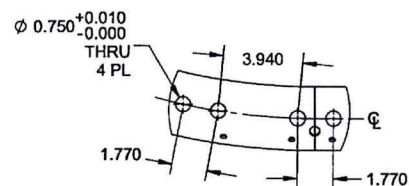
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



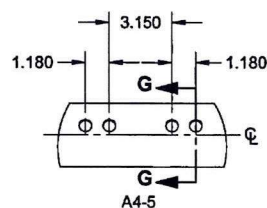
D2750-1 LH SKIDTUBE



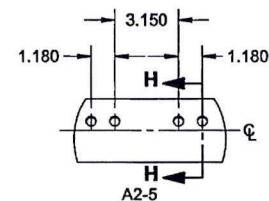
DETAIL A
SCALE 2X



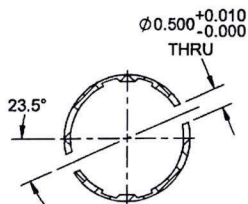
DETAIL B
SCALE 2X



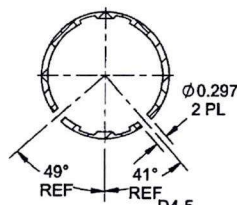
DETAIL C
SCALE 2X



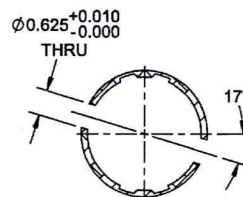
DETAIL D
SCALE 2X



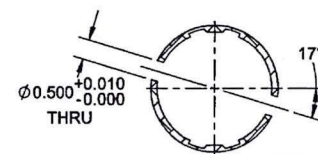
SECTION E-E
SCALE 4X, 2 PL



SECTION F-F
SCALE 4X, 17 PL



SECTION G-G
SCALE 4X, 4 PL



SECTION H-H
SCALE 4X, 4 PL

RELEASED
2010 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 5 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____

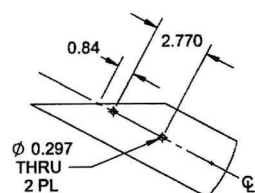
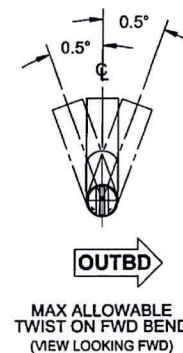
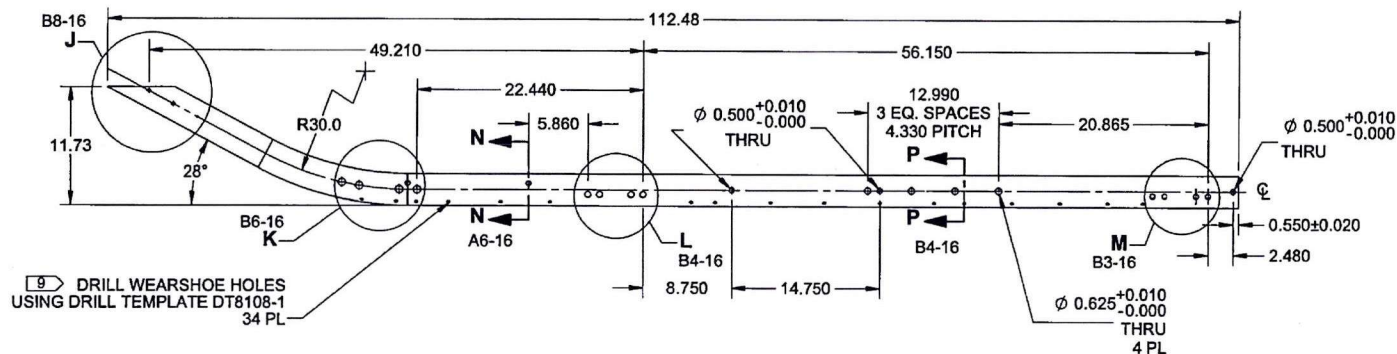


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

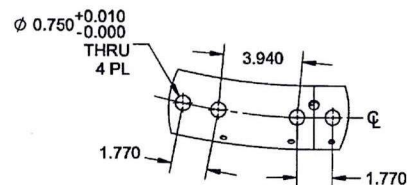
NCR No. _____

Route update only ☐

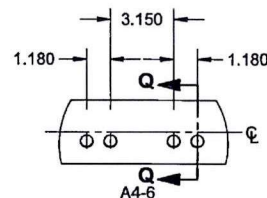
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



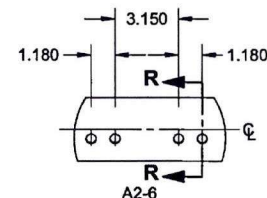
D7-6
DETAIL J
SCALE 2X



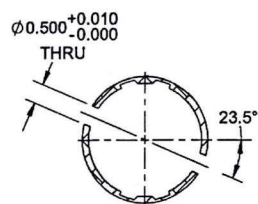
C7-6
DETAIL K
SCALE 2X



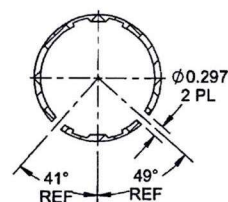
D5-6
DETAIL L
SCALE 2X



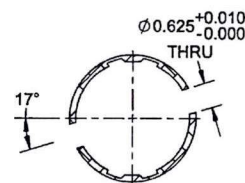
D3-6
DETAIL M
SCALE 2X



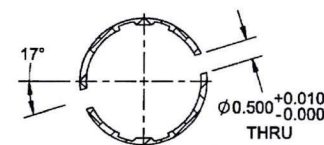
D6-6
SECTION N-N
SCALE 4X, 2 PL



D4-6
SECTION P-P
SCALE 4X, 17 PL



B4-6
SECTION Q-Q
SCALE 4X, 4 PL



B2-6
SECTION R-R
SCALE 4X, 4 PL

RELEASED
2018 OCT 19

APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 6 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE		18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____

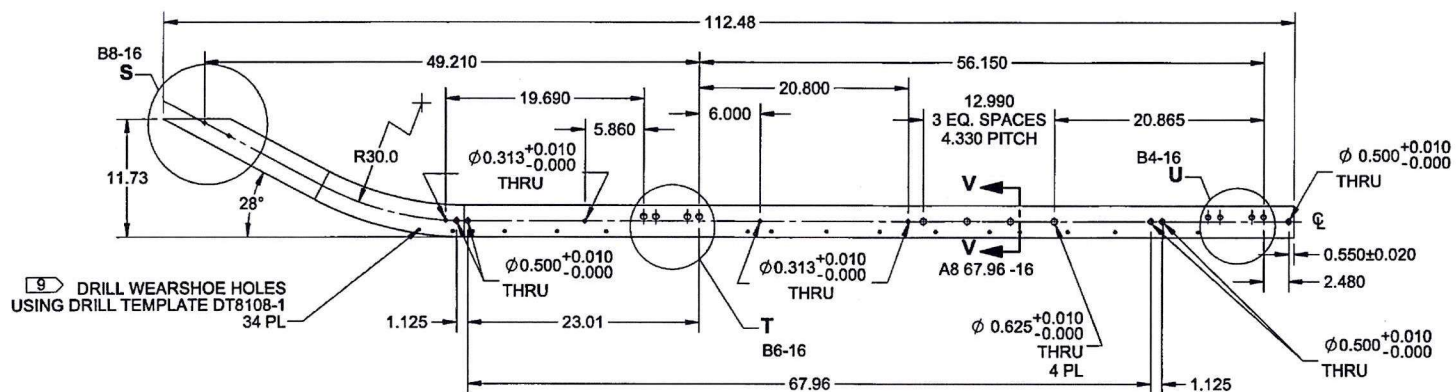


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

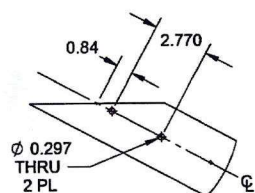
NCR No. _____

Route update only ☐

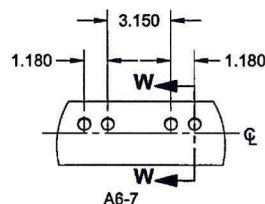
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



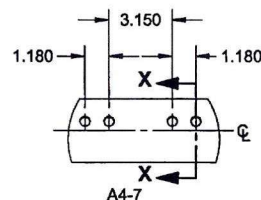
D2750-3 LH SKIDTUBE



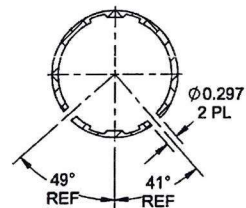
D7-7
DETAIL S
SCALE 2X



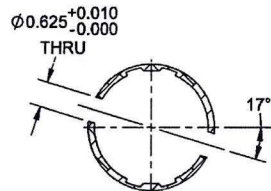
C5-7
DETAIL T
SCALE 2X



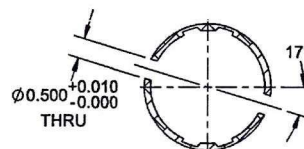
D3-7
DETAIL U
SCALE 2X



D4-7
SECTION V-V
SCALE 4X, 17 PL



B6-7
SECTION W-W
SCALE 4X, 4 PL



B4-7
SECTION X-X
SCALE 4X, 4 PL

RELEASED
2019 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO. D2750	REV. H
MFG. APPR.	DD	SHEET 7 OF 16	
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____

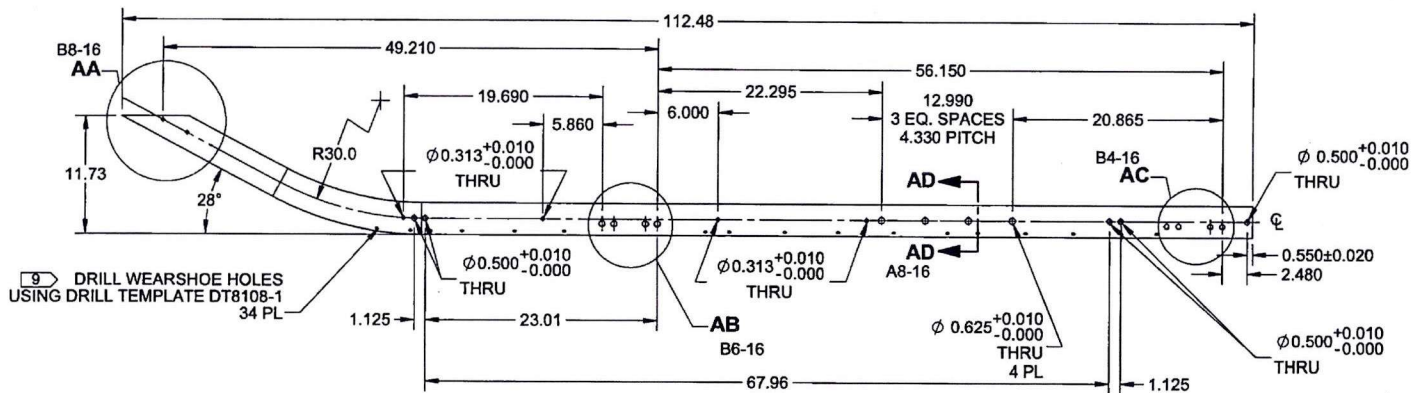


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

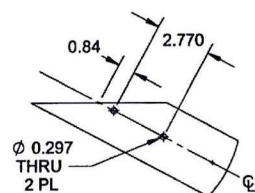
NCR No. _____

Route update only ☐

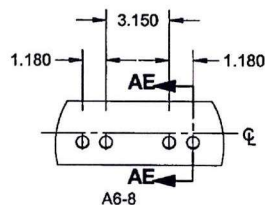
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			



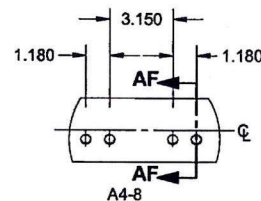
D2750-4 RH SKIDTUBE



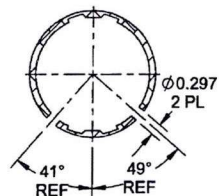
DETAIL AA
SCALE 2X



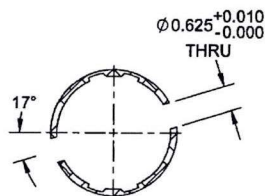
DETAIL AB
SCALE 2X



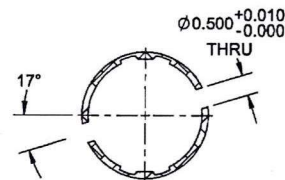
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
SCALE 4X, 4 PL



SECTION AF-AF
SCALE 4X, 4 PL

RELEASED
2018 OCT 19

APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 8 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE		18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____

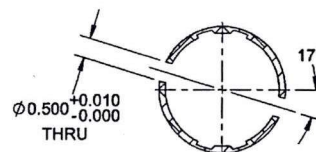
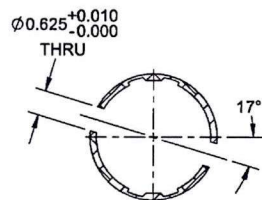
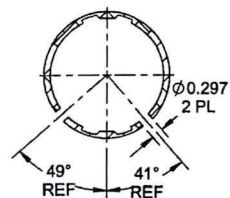
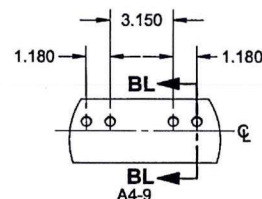
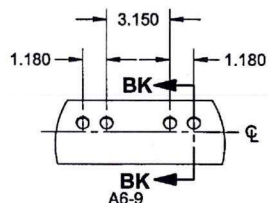
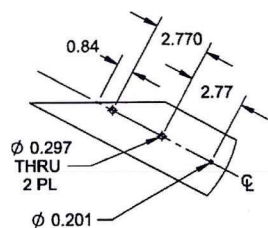
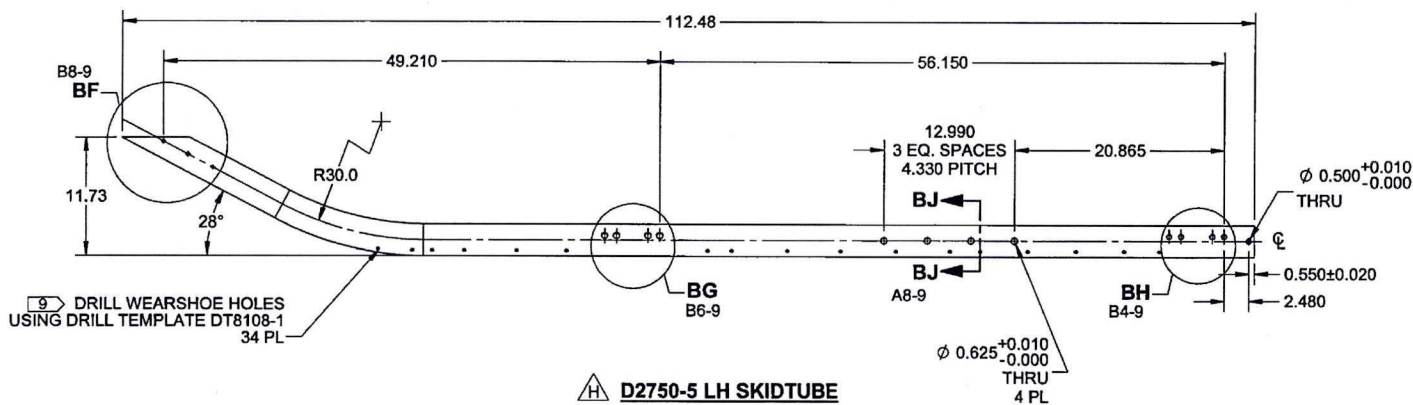


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



RELEASED
2019 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 9 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____

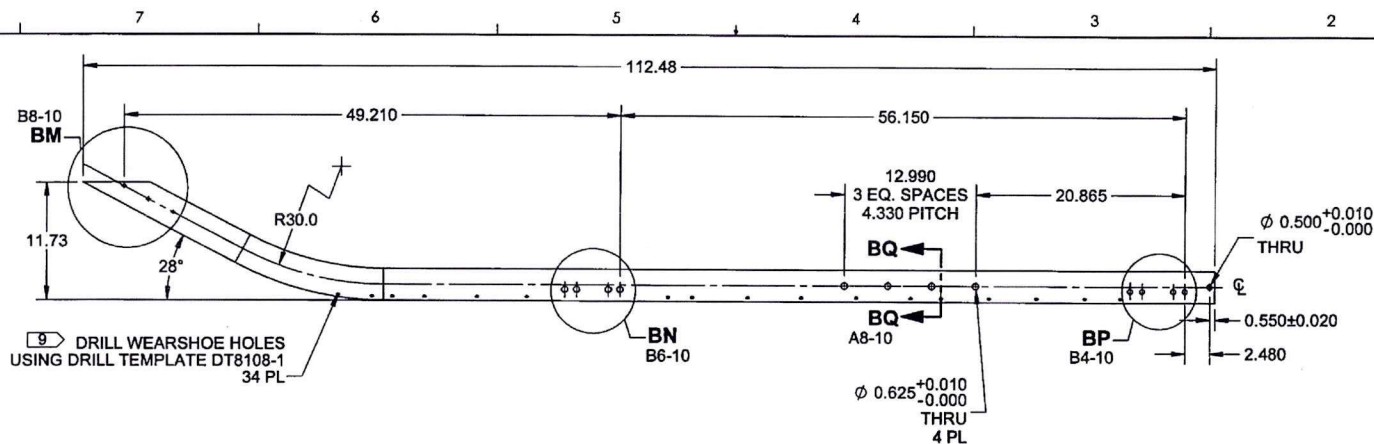


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

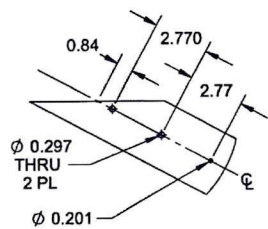
NCR No. _____

Route update only ☐

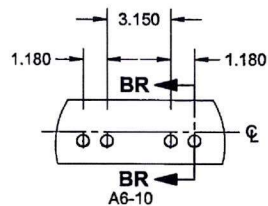
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



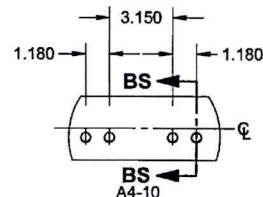
D2750-6 RH SKIDTUBE



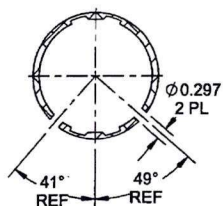
DETAIL BM
SCALE 2X



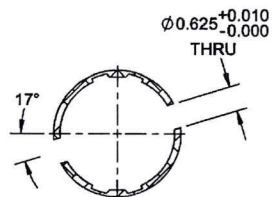
DETAIL BN
SCALE 2X



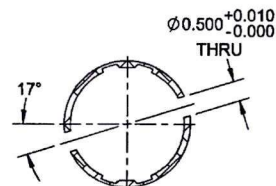
DETAIL BP
SCALE 2X



SECTION BQ-BQ
SCALE 4X, 17 PL



SECTION BR-BR
SCALE 4X, 4 PL



SECTION BS-BS
SCALE 4X, 4 PL

RELEASED
2019 OCT 19

APPROVED

DESIGN	MM
DRAWN	ZF
CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.05

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D2750** REV. H
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

A

Entered: _____ Date: _____

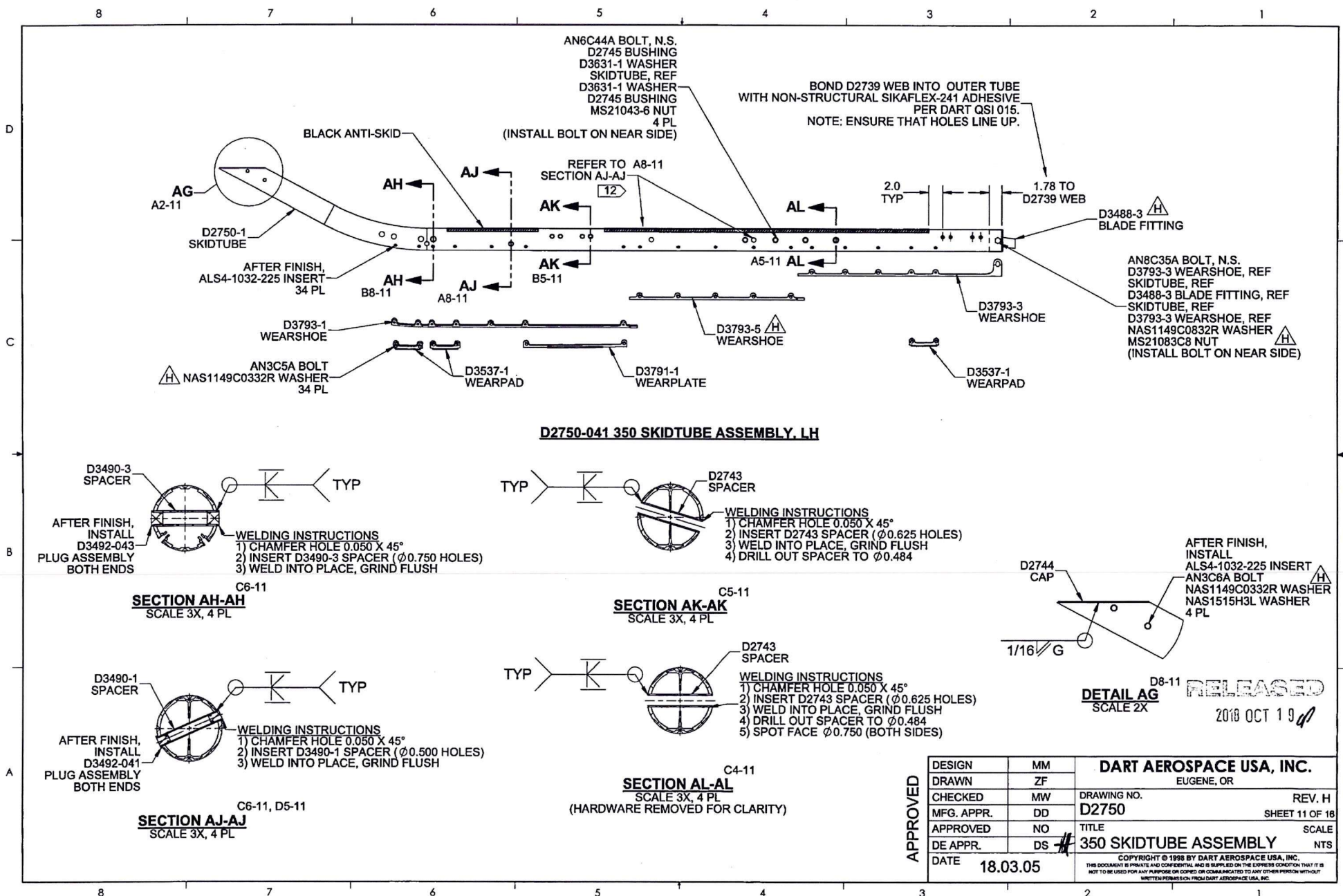


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Entered: _____ Date: _____

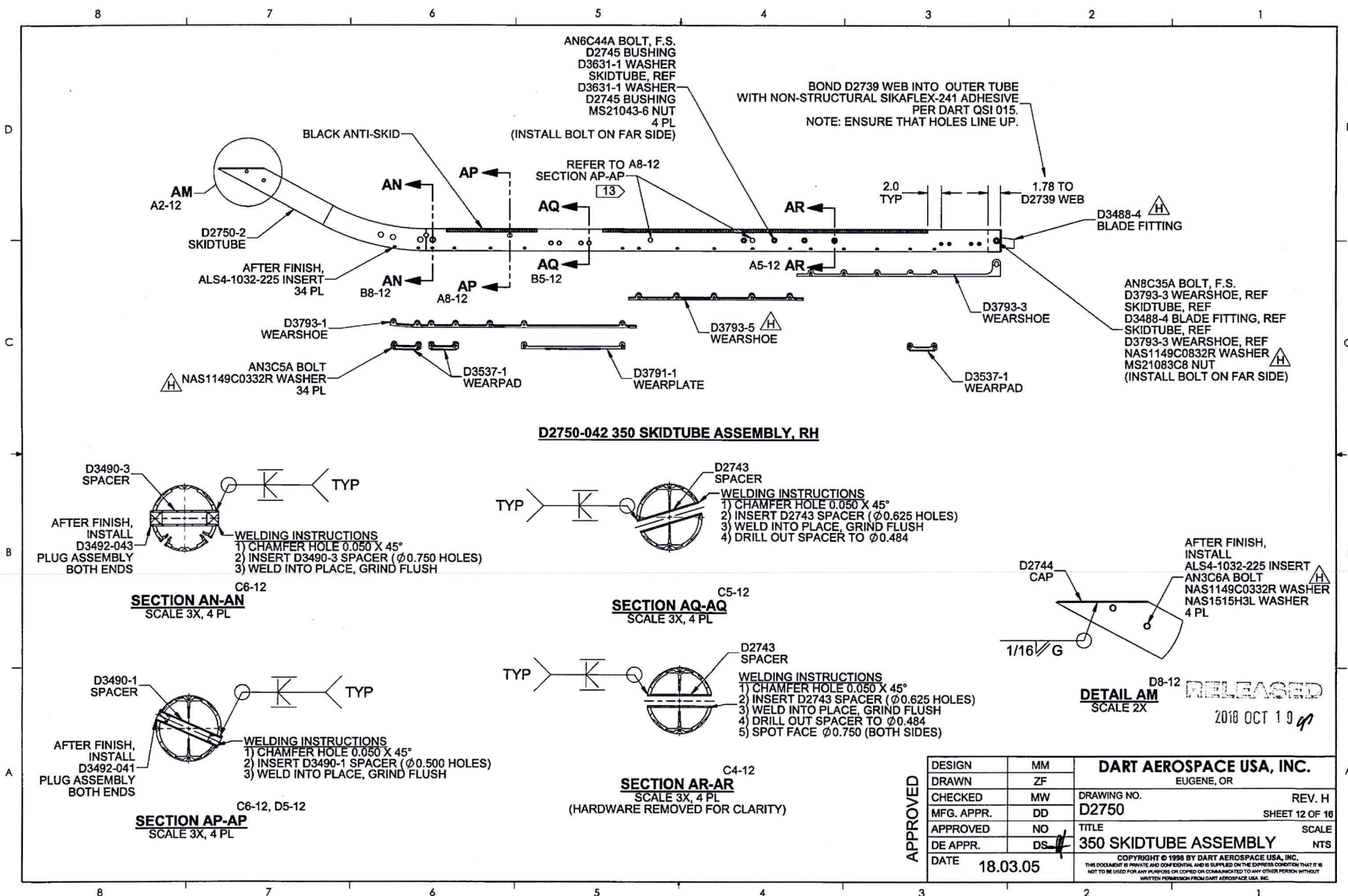


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Entered: _____ Date: _____



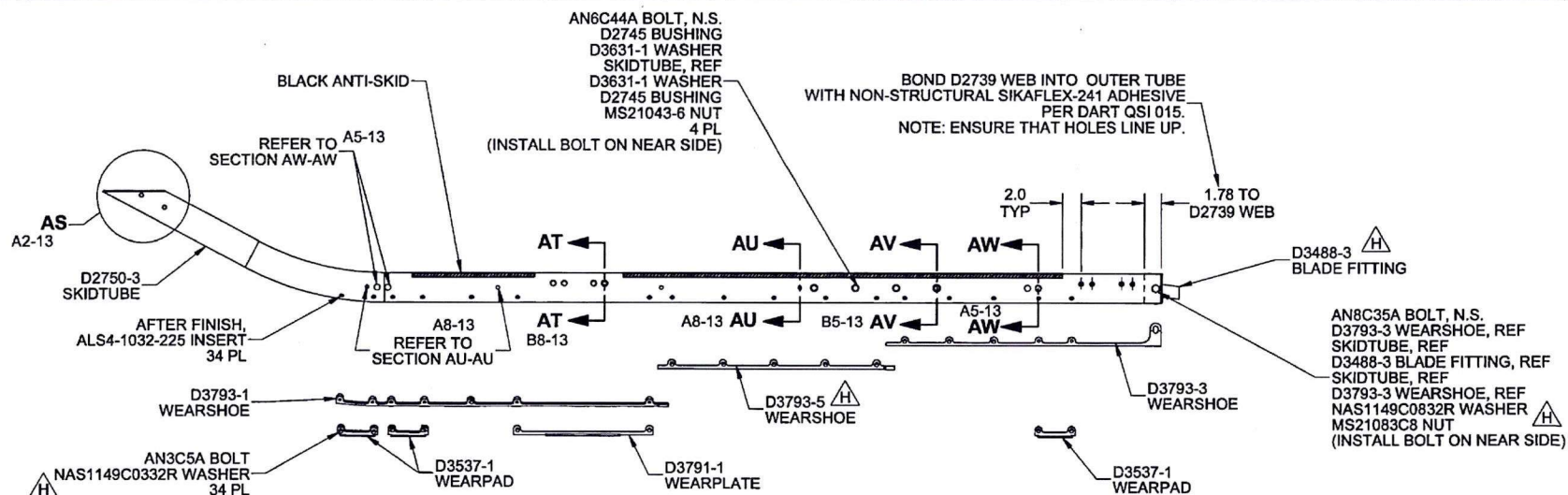
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

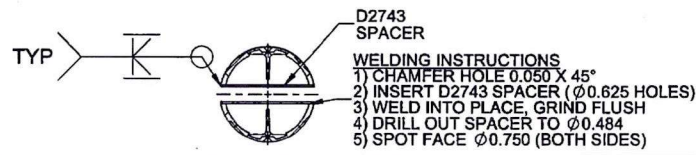
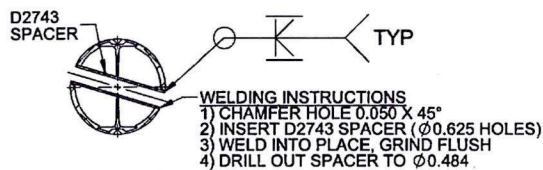
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

8 7 6 5 4 3 2 1

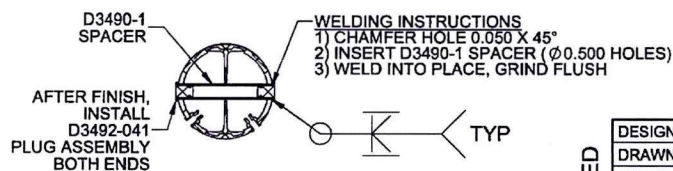
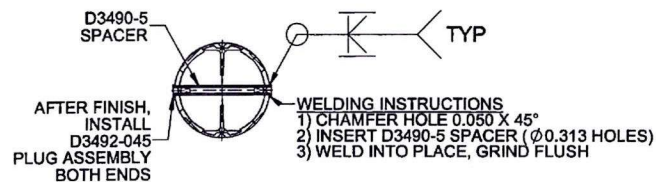
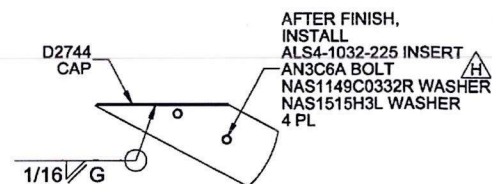


D2750-043 350 SKIDTUBE ASSEMBLY, LH



SECTION AT-AT
SCALE 3X, 4 PL

SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL

SECTION AW-AW
SCALE 3X, 4 PL

DETAIL AS
SCALE 2X

RELEASED
2010 OCT 19

APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 13 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE		18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____

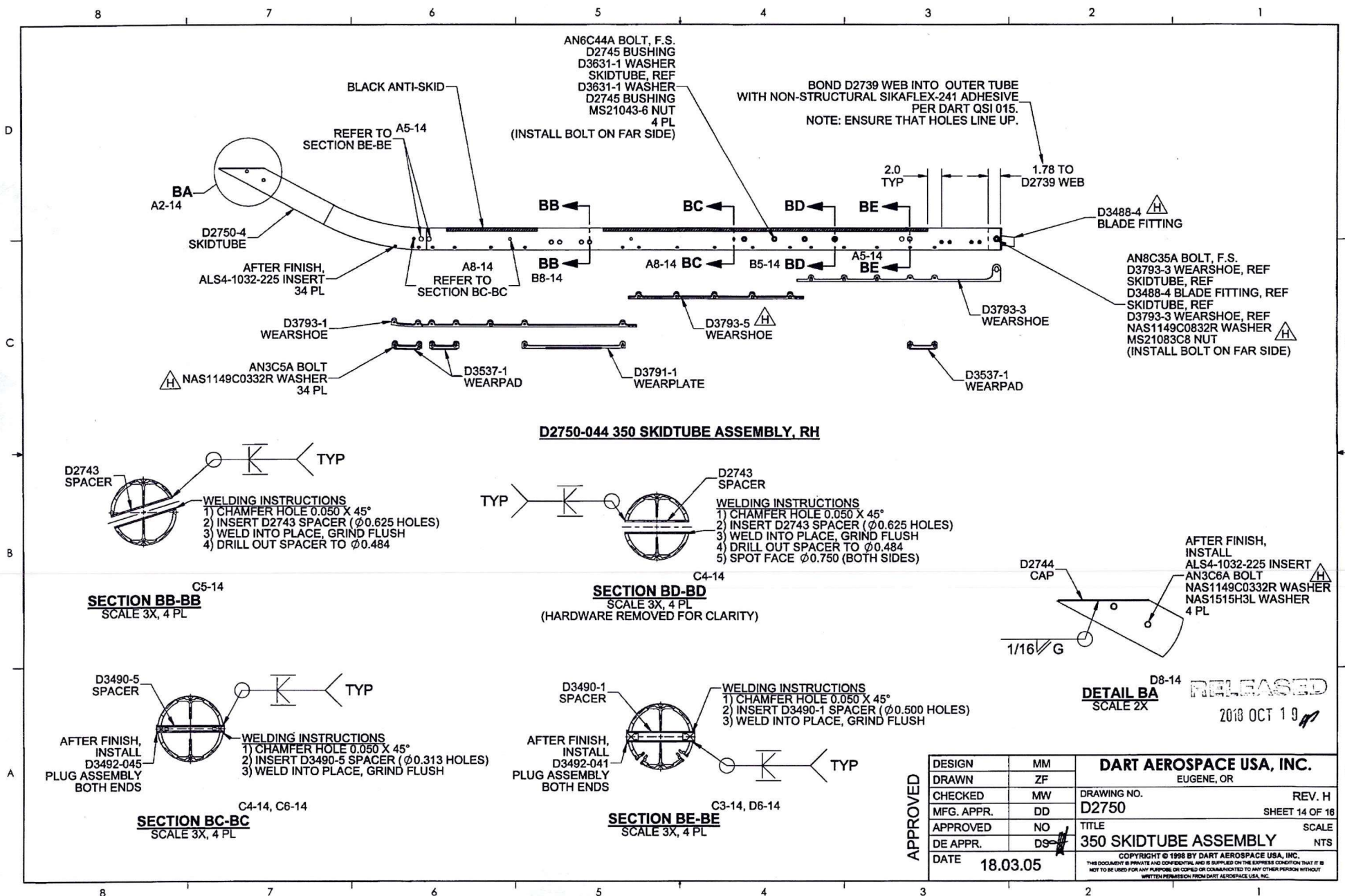


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Entered: _____ Date: _____



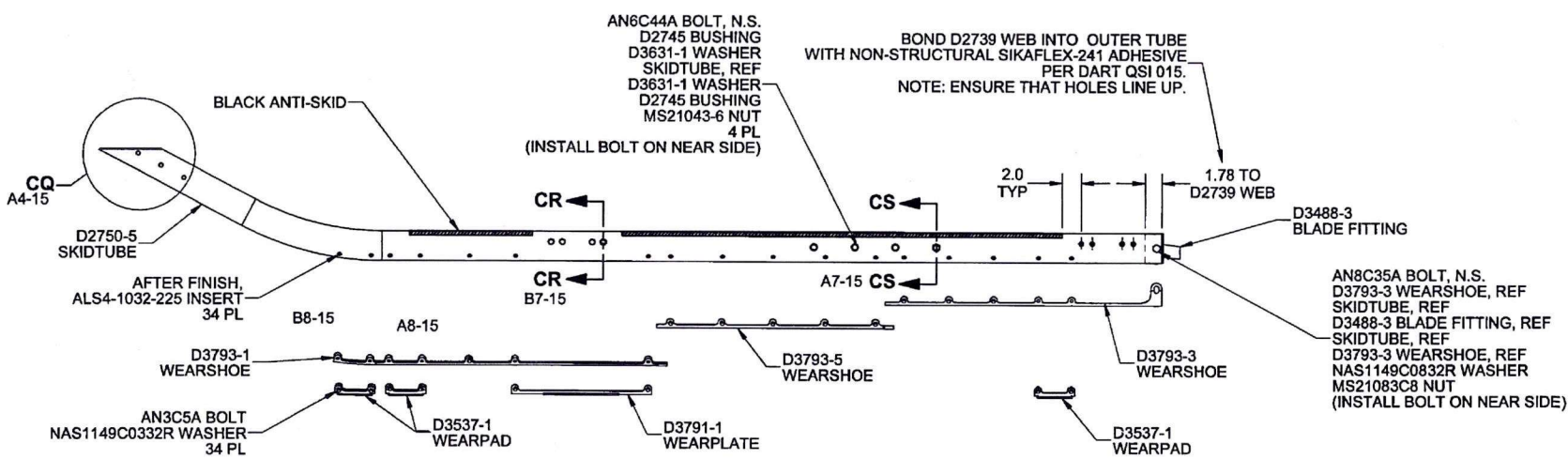
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

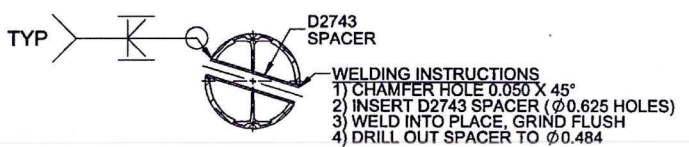
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			

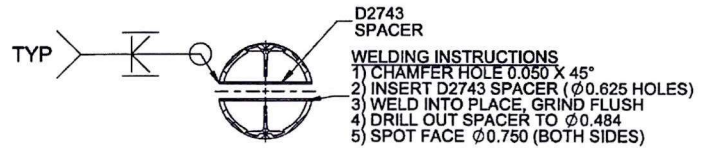
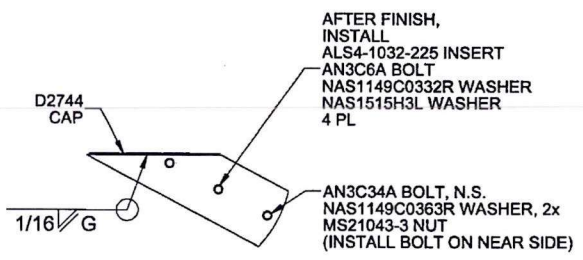
8 7 6 5 4 3 2 1



D2750-051 350 SKIDTUBE ASSEMBLY, LH



SECTION CR-CR
SCALE 3X, 4 PL



SECTION CS-CS
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

RELEASED
2018 OCT 19 42

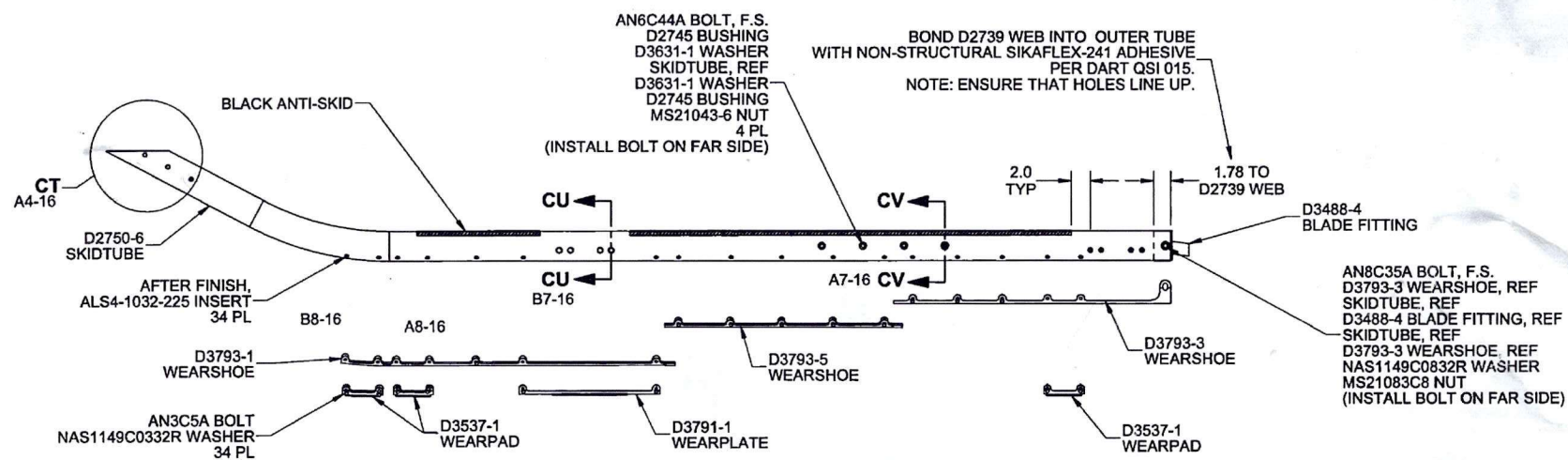
APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 15 OF 18
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
	DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

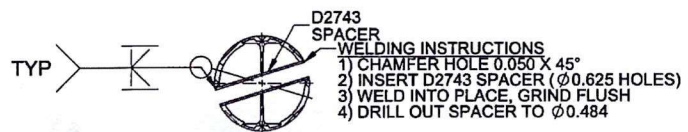
Route update only ☐

Part No. _____	DISPOSITION		DEPARTMENT/PROCESS			
	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :			MRB (QSI042)	
Description Work Order Deviation			Disposition			
			Completed By			
			Lead hand / Supervisor			
			QC / QA Coordinator			
Root Cause		FAULT CATEGORY				
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
Other/Details:						

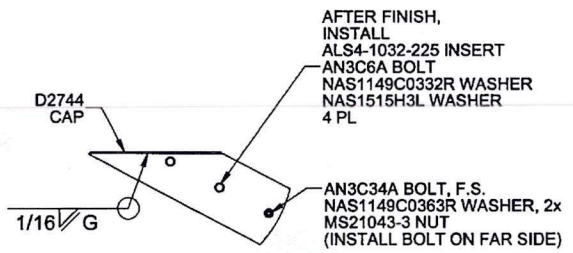
8 7 6 5 4 3 2 1



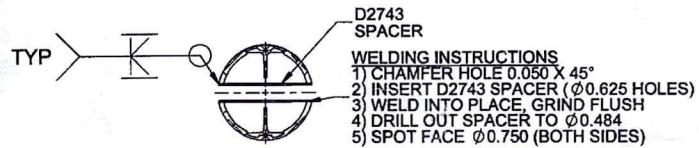
D2750-052 350 SKIDTUBE ASSEMBLY, RH



SECTION CU-CU
SCALE 3X, 4 PL



DETAIL CT
SCALE 2X



SECTION CV-CV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

RELEASED
2018 OCT 19

APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 16 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
	DATE	18.03.05	COPYRIGHT © 1996 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT

D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8	1	1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149DO863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: K

Date: 18.04.04